

Date: Tuesday, 01/05/2007 2:22:17 PM
 User: Linda Lacelle

Process Sheet

Split
SB 07/05/08

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE ASSY
Job Number	: 31913-1		
Estimate Number	: 12706		
P.O. Number	: <i>N/A</i>	Part Number	: D35725
This Issue	: 01/05/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3572 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31913	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 13/05/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>63</i> Um: Each
Comment	: Est Rev :A New Issue 07-01-16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0315 sf(s)/Unit Total : 1.8900 sf(s)

6061-T6 .080 Sheet

Batch: *M104186**SAD 07/05/04*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3572

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

*SAD 07/05/04**John 07/05/07*

(63)
(63)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/04**(63)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*Em 07/05/04**(63)*

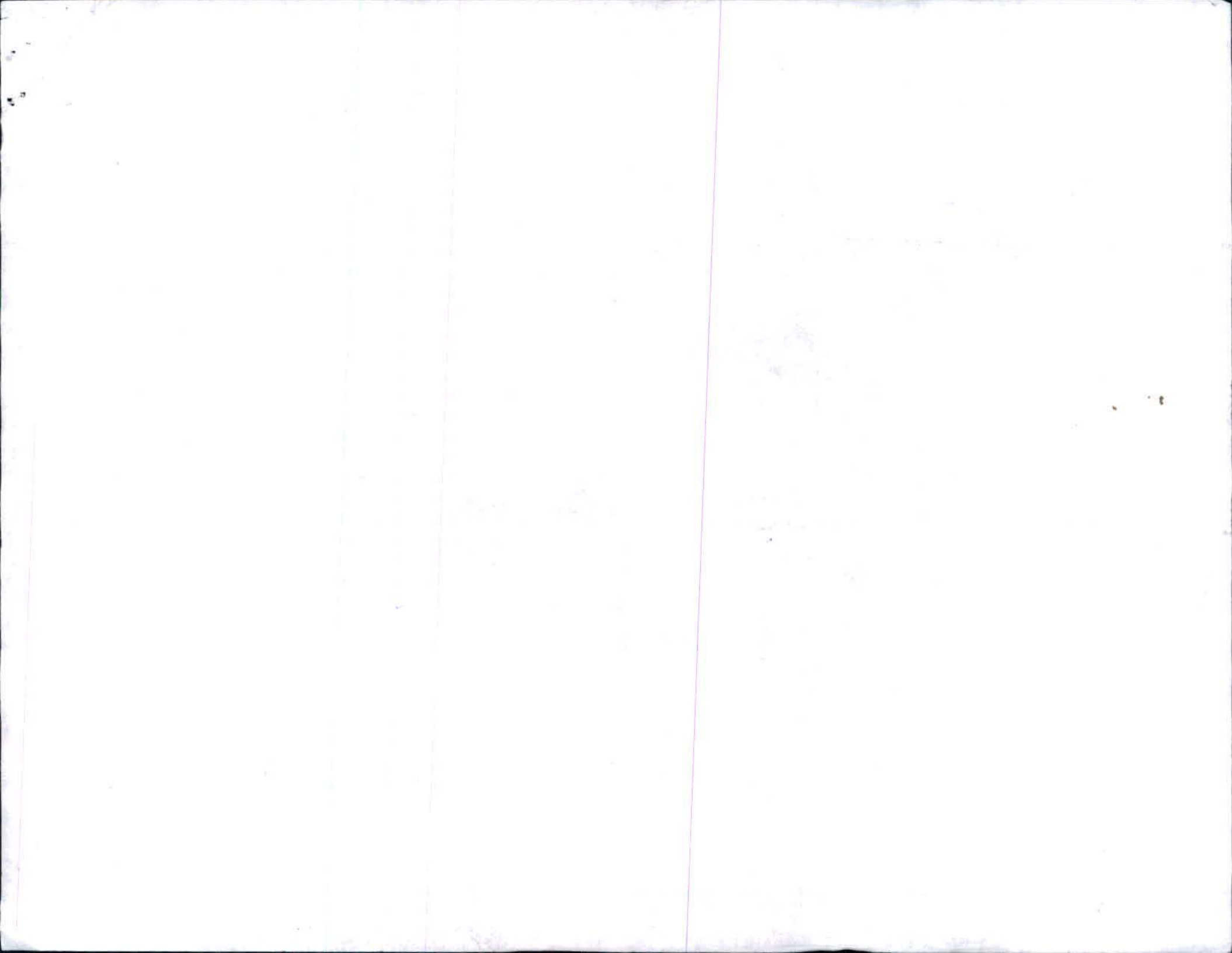
5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

form bend as per Dwg D3572 usin DT8943

*SB 07/05/18**(63)*



Date: Tuesday, 01/05/2007 2:22:17 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASS'Y

Job Number: 31913

Part Number: D35725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Lo 7/05/18

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA 29*

KE 01-05-18

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

40
01/05/22

Job Completion



Lo 7/05/22



Date: Tuesday, 4/17/2007 3:55:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE ASS'Y
Job Number : 31913	
Estimate Number : 12706	
P.O. Number :	Part Number : D35725
This Issue : 4/17/2007 S.O. No. :	Drawing Number : D3572 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : 31477	Material :
Written By :	Due Date : 5/12/2007 Qty: 60 Um: Each
Checked & Approved By :	
Comment : Est Rev A New Issue 07-01-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0315 sf(s)/Unit Total : 1.8900 sf(s)
 6061-T6 .080 Sheet
 Batch: _____

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3572
 Dwg Rev: _____
 Prog Rev: _____
 2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 form bend as per Dwg D3572

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

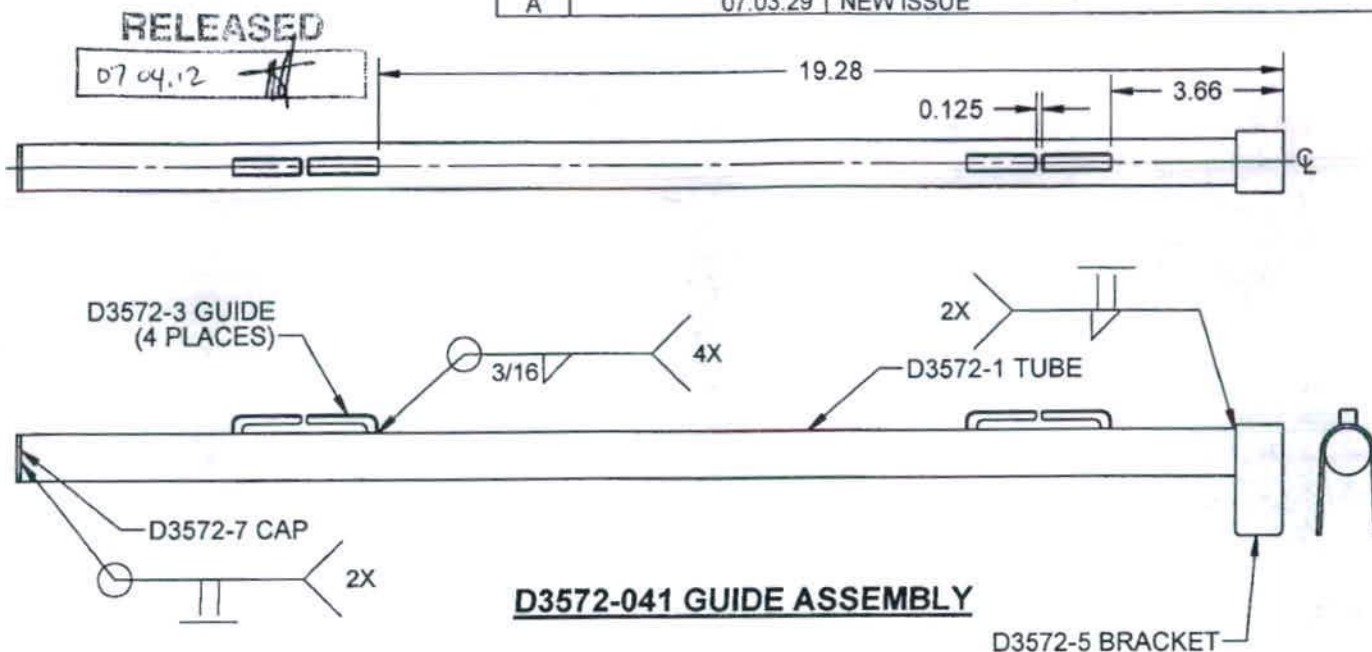
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

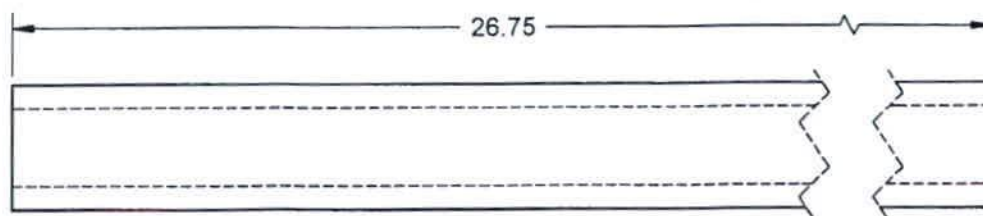
NOTE: Date & initial all entries

DART

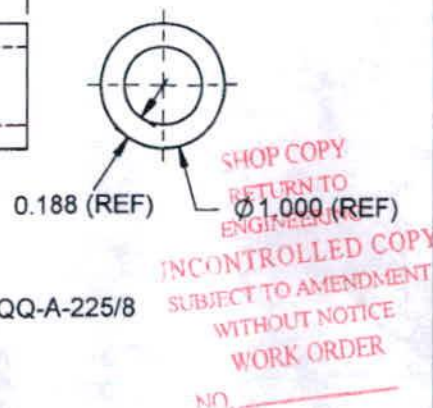
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3572	REV. A SHEET 1 OF 2
DATE 07.03.29	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV A	DATE 07.03.29	DESCRIPTION NEW ISSUE	

**D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE****D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

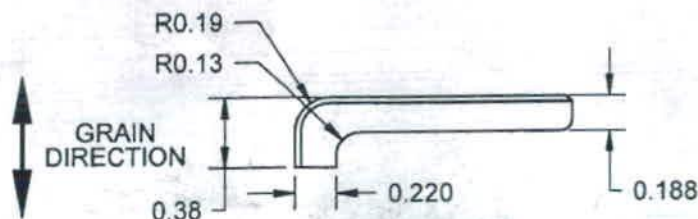
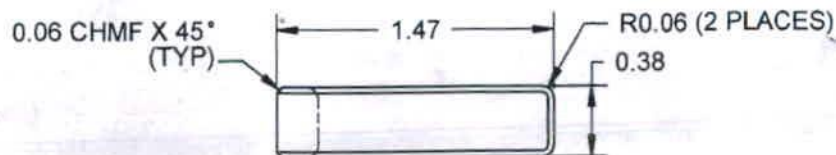


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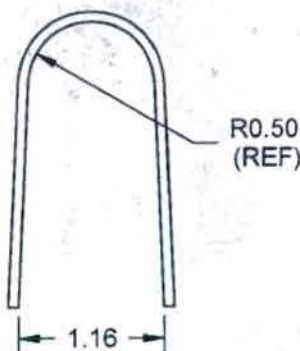
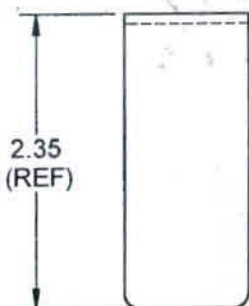
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.03.29		TITLE GUIDE ASSEMBLY	SCALE 2:3



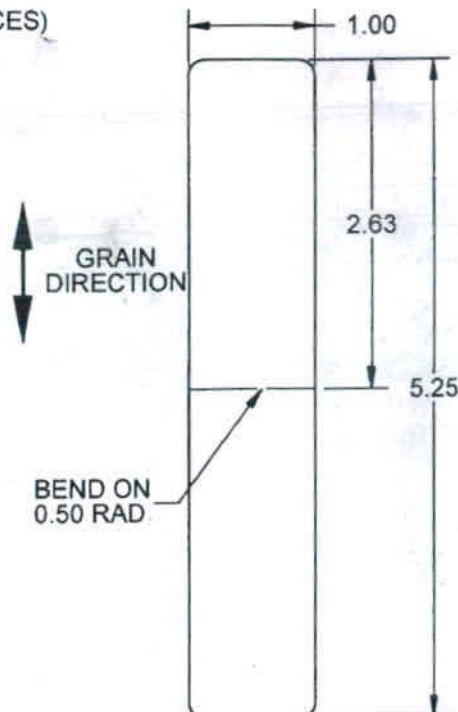
1 **D3572-3 GUIDE**

RELEASED

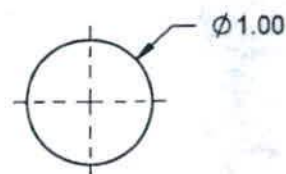
07.04.12 *[Signature]*



D3572-5 BRACKET
(MAKE FROM D3572-5F)



2 **D3572-5F FLAT PATTERN**



2 **D3572-7 CAP**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

D3572-3/-5/-7 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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